Work Orde				*961	117*							Page 1
Item ID: Revision ID: Item Name:	D2230-3 Lug			Accept	*N900	040	100)* s	etup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	1/22/13 2/15/13	Start Qty: 120.00 Req'd Qty: 120.00	*120° *120°		Cust Item I Customer:	D:						
Approvals:	Process P	lan: MLJ	Date: 13-01-24			ate:		F	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center I	D →	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr			·							
D2230 100 *100*	Re	BAND SAW		0.00			us 1888	(×	0	ع (و	orla	5 (12C
Bandsaw Jeaspa Bandsaw		Memo Cut D2423 e: Batch:	extrusion to 0.82"	0.00 - VC					~ <u></u>)	۰ د ر	<u> </u>	is the
110		HAAC ONG VERTICAL	MACHIDIDIC #1	0.00				2.		- 0 1		

0.00

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA927

FOLIO REV. DWG REV:

Check for crack while loading into the machine.

2- deburr

PD 18449 BS13-01-25

machine es per duy p2230 REU. C

NCR:	Vac	1	No
NCK:	Yes	/	INO

DQA: _____ Date: ____

NCR: Y	es / No				WORK ORDER NON-C	CONF	QA Closed:	Date	e: 						
Work Orde	ır.				DISPOSITION				AGAINST DE	PARTMENT/	PARTMENT/PROCESS				
Part N					Rework Scrap			Skid-tube Aachining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality			
NCR N	lo				Use-as-is Work Order Update] TI		oforming Large Fab	Finishing Composite						
Root				Descri	ption of work order update	Initi	ial	Ac	ction	Sign &	.,,				
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desc	cription	Date	Verification	QC Inspector			
Doc/Data											i				
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	Centre No	ot Conce	ntric to (_{2/5}	BOM/Route		ırdwa	re		Over/Under	tolerance	Temperature/Cure			
	Cracks	0011001			Broken/Damaged			on Incomplete		Part Incorre	<u> </u>	Weld			
	Crushed/	Crimped.		<u> </u>	Burrs	-		ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled			
	Cuffs	•			Contamination	Пм	ainte	nance		Part Moved	•				
	Heat Trea	at			Countersink	Мі	islabe	led		Positioned \	N rong				
ľ	Inspectio	n Strip in	Tube		Cut Too Short	Мі	isreac	i		Power Loss,	/Surge	Other			
Ì	Ripples in				Drill Holes	Of	fset								
	Torque W	Vaves in E	n	Drawing	Or	ut of (Calibration								
Ī	Turning S	equence			Finish	Out of Sequence									
	Wave/Tw	ist in Tul	ре		Folio	Ou	utside	Dimensions							

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• • •

Work Orde					Page 2					
Item ID: Revision ID:	D2230-3	1		Accept	*N900	1 040	100)* s	etup Start Stop	*NS1*
Item Name: Start Date: Required Date: Reference:	Lug 1/22/13 2/15/13	Start Qty: 120.00 Req'd Qty: 120.00		20* 20*	Cust Item Customer					*NS2*
Approvals:	Process QC:	s Plan:	Date:		*. *** *** *** *** *** *** *** *** ***	Date:		R	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II 120 CC *1 20* QC Quality Control	l. ue	Operation Description OC2-Inspect parts off ma Memo Cd + Chaptar		Set Up/ Run Hou 0.00	Tool ID	Tool #	Plan Code	Accept Qty		Reject Insp. Number Stamp
*130 *130* QC Quality Control		QCK-Inspect parts - secon		0.00	2 2S			Cour		

150

Chemical Conversion Coat per QSI005 4.1

0.00

150 HandFinish

Memo

0.00

Hand Finishing

							•	`				DQA:	Date:	
NCR:	⁄es	/ No					WORK ORDER NON-	COI	NFORM	/ANCE / UPI	DATE	•		
												QA Closed:	Date:	
Work Orde	er:						DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
Part N	۰ ۱۰۰						Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Des	crip	otion of work order update		Initial	Act	tion	Sign &		
Cause		Date	Step	Qty		C	or Non-conformance	Ch	nief Eng	Descr	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator Material etup Other Process upplier Training														
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		Bending Centre No Cracks Crushed/G Cuffs Heat Trea Inspection Ripples in Torque W	Crimped. t 1 Strip in Bend	Tube			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	 	Turning S			11	\vdash	Finish	\vdash	⊣ i	Sequence				

Outside Dimensions

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Wave/Twist in Tube

Folio

0.00

Memo

120

Quality Control

OC

NCR:	Yes	1	No
INC.D.	163	,	INU

DQA: _____ Date: ____

NCR: Y	es / No				WORK ORDER NON-O	CONFOR	MANCE / UP	DAIE	QA Closed:	Date:	
Work Orde	r·				DISPOSITION			AGAINST DE	PARTMENT	PROCESS	
Part No					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update	Ther	moforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	ription	Date	Verification	QC Inspector
Doc/Data	_										
Equip/Tooling	_										
Operator .	_										
Material	_				•						
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Other	_										
Process	_										
Supplier											
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Landin	g Gear	 			General	AULI CAI	LOONT				
Lanuin T	Bending				Bend	Grain		· [Ovalized	Γ	Pressure/Forced
<u> </u>	Centre N	ot Conce	ntric to C	_{0/5}	BOM/Route	Hardy			Over/Under	tolerance	Temperature/Cure
ŀ	Cracks	J. COINCE		·	Broken/Damaged	—	tion Incomplete	-	Part Incorre	<u> </u>	Weld
-		Crimped			Burrs		ctions Incomplete,	/Unclear	Part Lost/M	-	Wrong Stock Pulled
	Crushed/Crimped. Cuffs				Contamination	\vdash	tenance	·	Part Moved		_
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	Inspection Strip in Tube				Cut Too Short	Misre			Power Loss,	/Surge	Other
	Ripples in				Drill Holes	Offse	:	_			
<u> </u>	Torque V		Extrusion	,	Drawing	Out o	f Calibration				
ŀ	Turning S				Finish	Out o	f Sequence				
ļ	Wave/Twist in Tube				Folio	Outsi	de Dimensions				

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Page 4 January-23-13 8:57:25 AM D2230-3 Item ID: Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Lug **Start Oty: 120.00 Start Date:** 1/22/13 **Cust Item ID:** Required Date: 2/15/13 Req'd Qty: 120.00 *120* **Customer:** Reference: Run Start Process Plan: Date: Approvals: **Tooling:** Date: Stop Date: _____ QC: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp 190 Identify as per dwg & Stock Location: 0.00 *190* Packaging 0.00 Memo Packaging 200 QC21- Final Inspection - Work Order Release 0.00 MF 13-3-5 QC 0.00 Memo Quality Control

												DQA:	Date:	
NCR:	⁄es	/ No					WORK ORDER NON-	COI	NFORM	MANCE / UP	DATE	QA Closed:	Date:	
														
Work Ord	ar.						DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIR OIG	٠١٠.					i	Rework	7		Skid-tube	Crosstube		Water Jet	Engineering
Part I	lo.						Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•						Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR f	No.						Work Order Update]		Large Fab	Composite		Supplier	
	_		<u>-</u>									C: 0		T
Root		D-4-	Chara		Des		otion of work order update or Non-conformance		nitial		tion ription	Sign & Date	Verification	QC Inspector
Cause	\blacksquare	Date	Step	Qty			or Non-conformance	- Cn	ief Eng	Desc	πριοπ	Date	vermeation	QC IIISPECTOI
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	<u> </u>	Cracks				<u> </u>	Broken/Damaged	\vdash	4	on Incomplete	,, , <u> </u>	Part Incorre	<u> </u>	Weld
	_	Crushed/0		_	Burrs	-	-	ions Incomplete/	Unclear	Part Lost/M		Wrong Stock Pulled		
	<u> </u>	Cuffs Contamination Heat Treat Countersink						-	Mainte		 	Part Moved		
	<u> </u>	Inspection Strip in Tube Cut Too Short						\vdash	Mislabeled Misread			Positioned Wrong Power Loss/Surge		Other
							Drill Holes	\vdash	Offset	ı	L	Trower ross/	Juige _	Joures
	Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing							-	-	Calibration				
	\vdash	Turning Sequence Finish						-	4	Sequence				

Outside Dimensions

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Wave/Twist in Tube

Folio

Picklist Print

January-23-13 8:57:25 AM

Work Order ID:

96117

Parent Item:

D2230-3

Parent Item Name:

Lug

Start Date: 1/22/13

Required Date: 2/15/13

Page 1

Start Qty: 120.00

Required Oty: 120.00

Comments:

IPP D00.05.18Added inspection level 8, and removed P/O for powder

coatEC

IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED

BY:EC

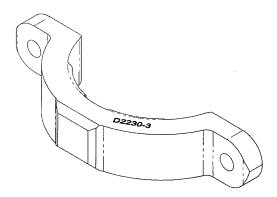
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P		Purchased	No				Each	180.0000		120	///	110	- (1·
LUG	•										199	2/2	<u> </u>
				Location		Loc Qty	<u>Lo</u>	c Code			/	C .	
				ST		180							
				9495	57	180							
D2423 Lug Extrusion		Manufactured	No			100	f	761.4340	0.0683	8.6273	64 213/611	25	
				Location		Loc Qty	<u>Lo</u>	oc Code					
				MAT006		425.434							
				4372	22	161.5							
				879:	53	263.934							
				Metec		336							
				935	51	336				<u>8.6</u> 3			

											DQA:	Date:	
NCR:	'es	/ No				WORK ORDER NON-	COI	NFORM	AANCE / UPDAT		_	···········	
											QA Closed:	Date:	
Work Orde	ar.					DISPOSITION				AGAINST DEI	PARTMENT/	PROCESS	
Part N	•					Rework Scrap Use-as-is		ſ	Machining S	rosstube Small Fab Finishing		Water Jet I. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo.			. .		Work Order Update	<u>.</u>		~ - -	omposite	Nec/3ton	Supplier	
Root					Descr	ription of work order update	\prod	nitial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Description	on	Date	Verification	QC Inspector
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		Bending			Г	Bend		Grain			Ovalized		Pressure/Forced
!		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks Broken/Damaged						Inspect	on Incomplete		Part Incorred	:t	Weld
		Crushed/Crimped. Burrs						Instruct	ions Incomplete/Uncl	ear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs Contamination							Mainte	nance	:	Part Moved		
		Heat Trea	t			Countersink		Mislabe	eled		Positioned V		-
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d	L	Power Loss/	Surge	Other
	Ripples in Bend Drill Holes						L	Offset					
	Torque Waves in Extrusion Drawing							Out of Calibration					
	Turning Sequence Finish						<u>_</u>	4	Sequence				
	Wave/Twist in Tube Folio						-	Outside	Dimensions				

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D2230-1

D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG



AJS

CP

09.01.16

99.12.13

G

D

NOTES:
1) MATERIAL: MAKE FROM D2423 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS

OF 0.015±0.005. 7) WEIGHT: -1: 0.16 lbs

-3: 0.14 lbs

8

96117MC5

13-01-24

Ē RE-DESIGN BW 95.01.04 D RE-DESIGN 95.01.04 BW С RE-DESIGN BW 94.03.30 REV. DESCRIPTION BY DATE DESIGN BW DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. G D2230 MFG. APPR. SHEET 1 OF APPROVED SCALE MOUNTING LUG DE APPR. NTS COPYRIGHT © 1994 BY DART AEROSPACE LTD

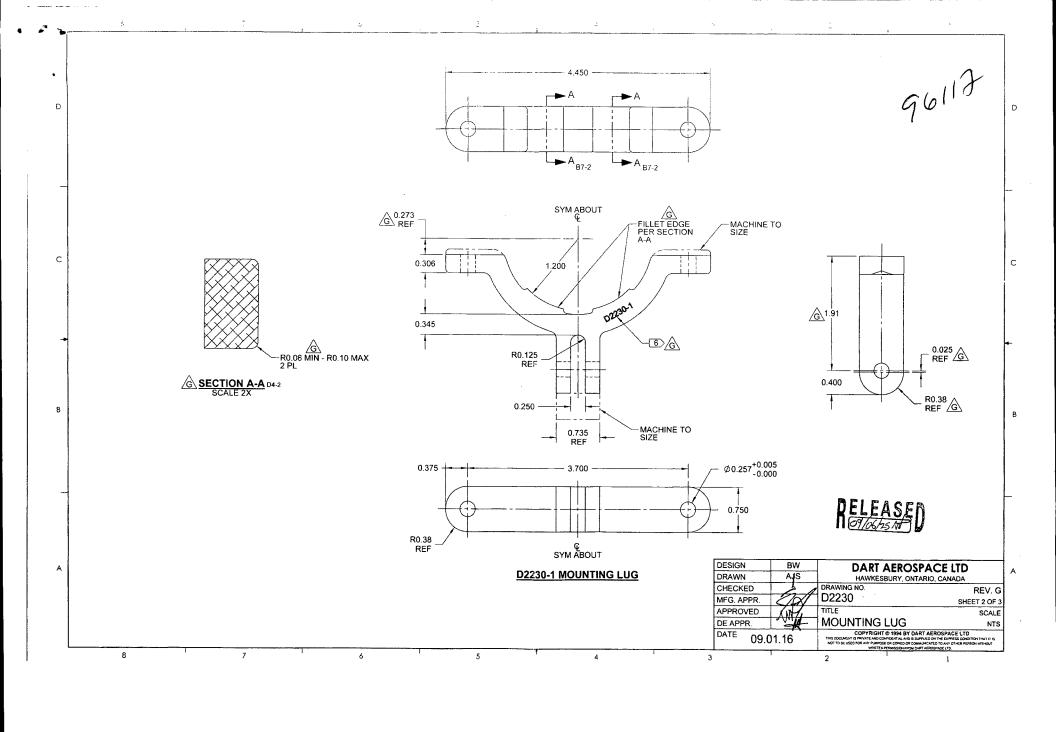
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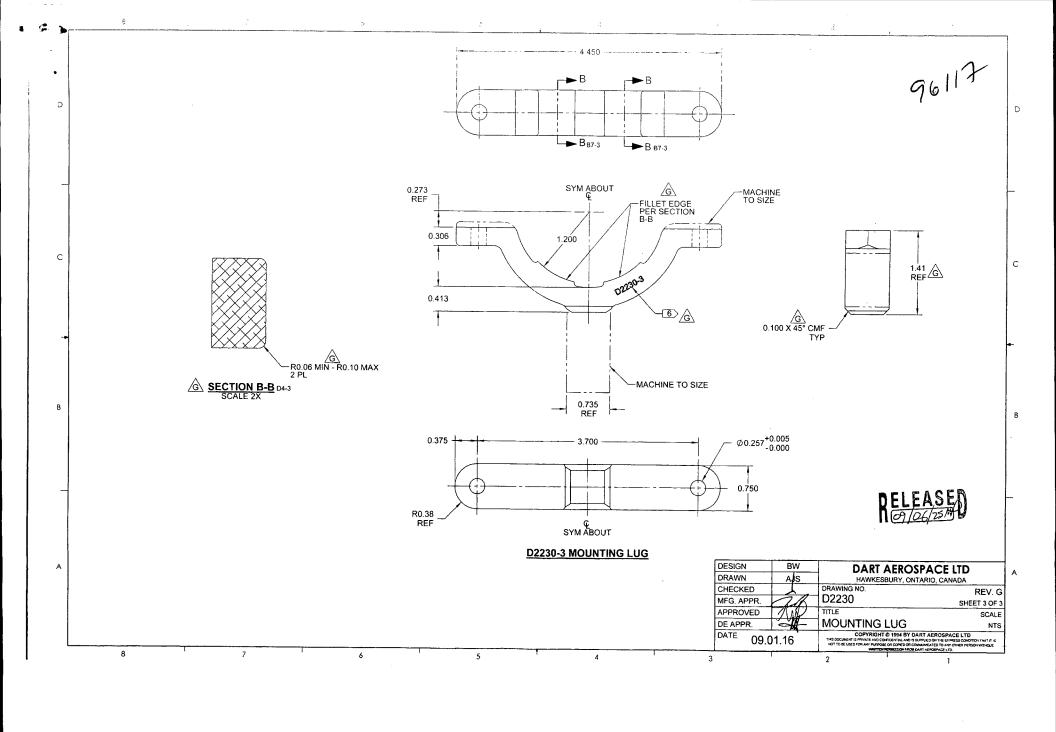
NOT TO BE USED FOR MAY PROPER OF COMPANDING THE THIS ON WHITHOUT MATTER THE THIS OF THE THI DATE 09.01.16

2

REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.

REDESIGN; R1.200 WAS 1.100







Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18949

Purchase Order Date 1/25/13 PO Print Date 1/28/13

Page Number 1 of 1

Order From:

VC-MET003

METEC METAL TECHNOLOGY INC. 20 TERRY FOX DRIVE PO BOX 781 VANKLEEK HILL, ON KOB 1RO

Contact Name Vendor Phone Vendor Fax

613 678 3957 613 678 3956

Vendor Account Nbr

Buyer

Requisition Nbr Tax Resale Nbr

Terms Currency FOB

Brigitte Golden

10127-2607

Net 10 CAD

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA

Line	Nbr Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Req Qty/ Ship Method Unit Price Taxable Unit of Measure	Extended Price
1	D2230-1	Lug	1/25/13 120.00 Dart Truck \$18.9500 Yes Each /3/2/13	\$2,274.00
2	D2230-3	Special last:	AS PER DWG: D2230 REV: G B96247 1/25/13 120.00 Dart Truck \$13.6000 Yes Each	\$1.632.00
		Special Inst:	AS PER DWG: D2230 REV: G B96117	
3	D3910-3	Crosstube Lug	1/25/13	\$2,000.00
		Special lust:	AS PER DWG: D3910 REV: B B96229	

No substitution or deviation without consent.

PO Total:

\$5,906.00

Certificate of Conformity or Material Certification required/-YES NO

Change Nbr:

3

Change Date: 1/28/13



20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0, Canada Tel: (613) 678-3957 Fax: (613) 678-3956

Delivery Slip No.:

19134

Date:

Feb 15, 2013

Page:

Sold to:		Ship to:			
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7		Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7			
Order No.:	18949	Sold By: Dewar, Eric			
Shipped By:	your truck	Ship Date:			

	Description	Unit	Ordered quantity	Shipped quantity	Bäckorder quantity
D2230-1	Mounting Lug	Each	120		
D2230-3	Mounting Lug	Each	120	120	
3910-3 Crosstube Lug		Each	30		
				i	
					Ì
Should there	goods must be inspected upon receipt to confirm compliance. be discrepancies please notify METEC within 30 days of delivery. be otherwise deemed accepted.				
Receive	d by	Thank you for your order!			

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0 Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont. K6A 1K7

same

QUANTIT

PART NUMBER

PART NAME

P.O. NUMBER

120 \ \ \ D2230-3

Lug

18949

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shigi Walz

Vankleek Hill, February 15, 2013